

Date: Monday, 03/11/2008 10:39:08 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW LUG
Job Number : 43141	
Estimate Number : 11217	
P.O. Number :	Part Number : D34041
This Issue : 03/11/2008 S.O. No. :	Drawing Number : D3404 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37061	Material :
Written By :	Due Date : 10/11/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JUL 08.11.03</u>	
Comment : Est Rev:A 05.09.01 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750X2500	304 BAR .750 X 2.50
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Comment: Qty.: 0.2406 f(s)/Unit Total : 4.8111 f(s)  
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick  
 (M304B0.750x02.500)  
 Identify for D3404-1  
 Batch: 1100682 (x32)

M101933 (x9)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank: 2.750" long

N.A 08/11/05 (40)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404  
 Dwg Rev: B Folio Rev: B

2-Deburr

25/08/11/06 / N.A 08/11/05 (40)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/11/05 (40)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JUL 08/11/08 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3404-1 PAR #: N/A Fault Category: Pro-Mach NCR: Yes No DQA: 10 Date: 08/11/11  
 (412-742-011/013) IS Resolution: Scrap Disposition: Scrap QA: N/C Closed: 10 Date: 08/11/20

NCR: <u>43141</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8.F</u> <u>08/11/07</u>	<u>3.0</u>	<u>One part fly off the vise during the first operation.</u>  <u>R.C. Rougher cutter was</u> <u>worn out</u>	<u>BS/WR</u>	<u>Change the tool / Replace</u> <u>Scrap &amp; replace part Qty 1</u> <u>B M101933</u>	<u>8.F</u> <u>08/11/07</u>	<u>08-11-07</u>	<u>BS/WR</u>	<u>08-11-07</u>

NOTE: Date & initial all entries

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Drawing Name: GHW LUG

Job Number: 43141

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 8/11/10 (40)  
FINAL INSPECTION/W/O RELEASE

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

08/11/10 MF

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

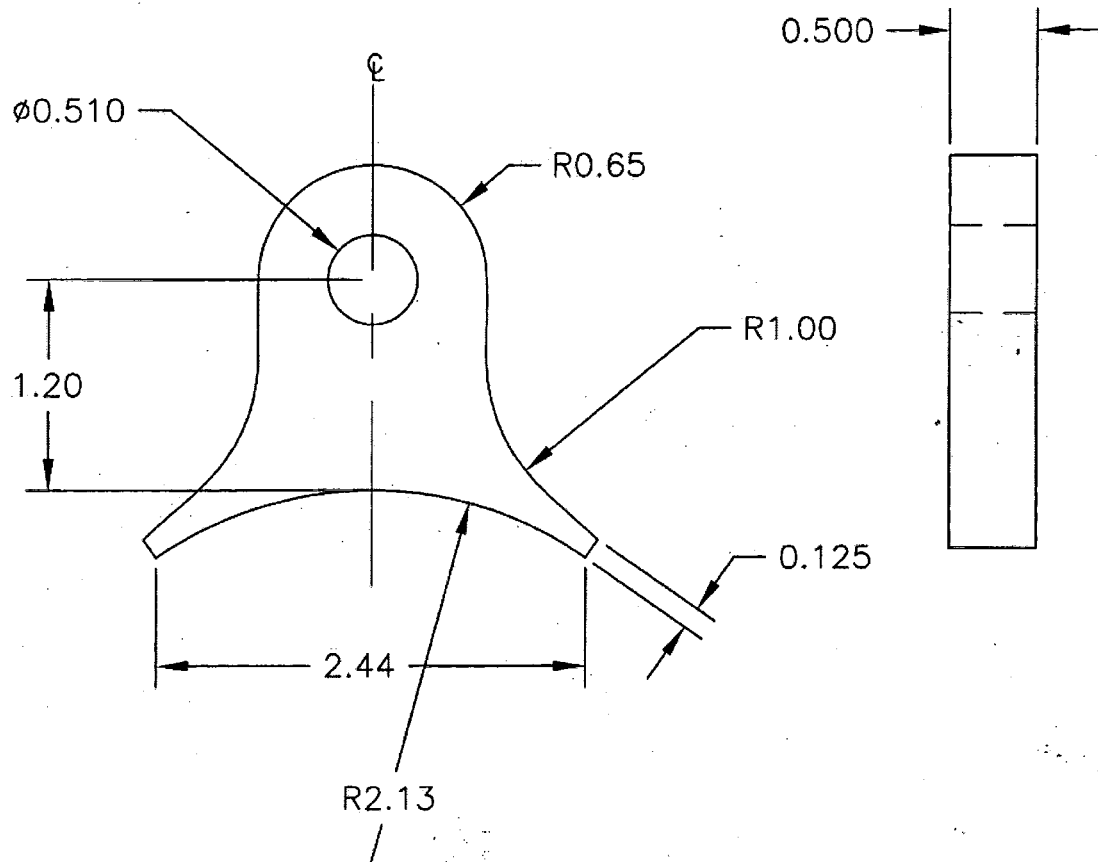
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3404	REV. B SHEET 1 OF 1
DATE 05.06.14		TITLE GHW LUG	SCALE 1:1
A	05.03.08	NEW ISSUE	
B	05.06.14	UPDATE M-SPEC	

**RELEASED**  
05-08-09 *[Signature]***D3404-1****D3404-1 GHW LUG**

- 1) MATERIAL: AISI 304/316 SS BAR  
(REF. DART SPEC. M304B0.750X02.500)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP CORNERS 0.03 TO 0.06
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43141

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